

Date: Thursday, 3/22/2007 1:53:16 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT TUBE ASSEMBLY
Job Number : 31317	
Estimate Number : 10699	
P.O. Number :	Part Number : D3391025
This Issue : 3/22/2007 S.O. No. :	Drawing Number : D3391 REV F
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : F
Previous Run : 31321	Material :
Written By :	Due Date : 4/10/2007 Qty: 1 Um: Each
Checked & Approved By : <u>07.03.22</u>	
Comment : Est Rev B 06-02-07 ECN773 dwg rev. D EC	
Est Rev C 06-03-28 Update Manufacturing Instructions	
JLM	
est rev D 07.03.20 revF dwg ec	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D6014090

ALUMINUM EXTRUSION



Comment: Qty.: 1.0000 f(s)/Unit Total : 1.0000 f(s)

ALUMINUM EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D6014-090	Extrusion	<u>26546</u>

Identify as D3391-3

MS 07/04/01

2.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

Turn as per Folio FA599

Rev: F & Dwg D3391 Rev: F

MS 07/04/01

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 07/04/01

4.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS

1-Machine as per Folio FA 599 Rev: AK & Dwg D3391 Rev: 6

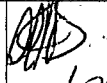
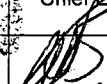
→ 2-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

3-Deburr

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-04-05	4	2.00" slot is .230 on one side	 07/09/05 SCRAP	incorrect offset / operator error. offset was corrected.	BG 07-04-05		 07/09/05	

NOTE: Date & initial all entries

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Job Number: 31317

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

7.0

BENDING

BENDING MACHINE



Comment: NC Bender

Form as per Dwg D3391 Using Bend Prog 3391025

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill Tube as per D3391 using DT8809 (HOLES MARKED "A" ONLY)

3-Drill and c' sink wearshoe holes as per Dwg D3391 Using DT8878(Mid Tube) & DT8217 Wearplate Jig

4-C'sink holes for float bag (4 holes per side) as per Dwg D3391

5-Deburr

Tools: rill

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number: 31317

Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Aft Cap

Pick:

Qty

Part Number

Description Batch

1

D2646

Aft Cap

15.0

D35371

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPAD

16.0

D35377

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Wearpad

17.0

D35531

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

18.0

D35533

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

19.0

AESS10KB366

INSERT



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Insert

Pick:

Qty

Part Number

Description

Batch

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

14 AESS10KB366 Insert

20.0

AESS10KB316

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB316	Insert	

or NAS1330C3KB316

21.0

AESS10KB266

INSERT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	AESS10KB266	Insert	

or NAS1330C3KB266

22.0

NAS1330C3KB166

INSERT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
8	NAS1330C3KB166	Insert	

23.0

AN3C4A

BOLT



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
2	AN3C4A	Bolt	

24.0

AN3C5A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part Number: D3391025

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Inventory

Pick:

Qty	Part Number	Description	Batch
2	AN960C10L	Washer	

26.0

NAS1515H3L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description	Batch
2	NAS1515H3L	Washer	

27.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install inserts as per Dwg D3391

2-Install Aft Cap as per Dwg D3391

A/R Sikaflex-241/-291

Sikaflex expiry date: \_\_\_\_\_

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion:



*h 3/22/07*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	31317
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: <del>E</del> F 24 07.03.22	Page 1 of 1	

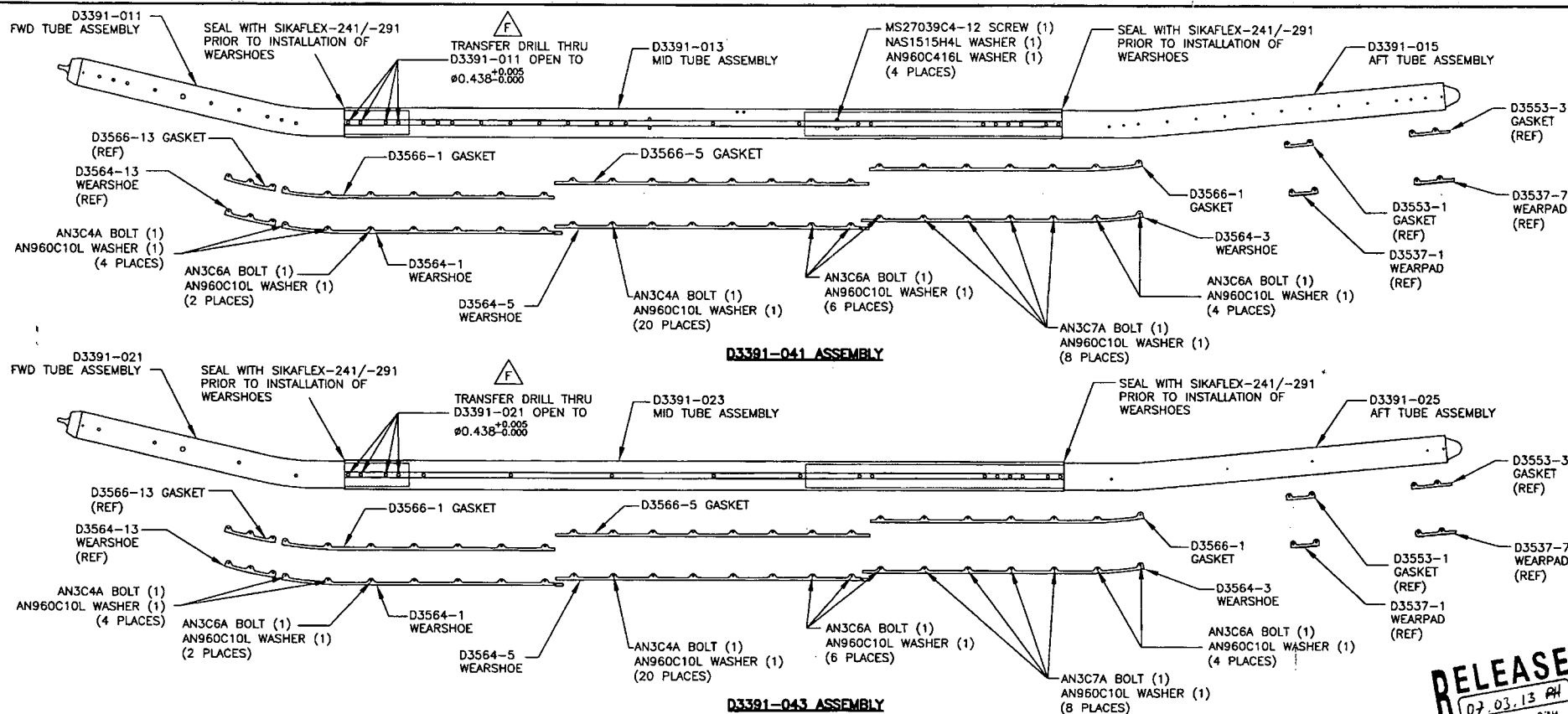
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	14.000	✓			
3.500	+/-0.010	3.501	✓			
88.93	+/-0.030	88.93	✓			
44.995	+/-0.030	44.995	✓			
3.200	+/-0.010	3.205	✓			
1.526	+0.000/-0.030	1.521	✓			
0.200	+/-0.010					
7.500	+/-0.010	7.498	✓			
27.750	+/-0.010	27.750	✓		Tape measure	
31.750	+/-0.010	31.750	✓		Tape measure	
35.250	+/-0.010	35.250	✓		Tape measure	
<del>0.400</del>	+/-0.010					
<del>00.208</del>	+0.005/-0.001					
3.300	+/-0.010	3.300	✓			
0.200	+/-0.010					
3.520	+/-0.010	3.522	✓			
0.687	+0.010/-0.000	0.688	✓			
R0.062	+/-0.010	0.062	✓		R-4	
Ø0.484	+0.005/-0.001	0.484	✓			

Measured by: MS	Audited by:	Prototype Approval:	N/A
Date: 07/04/01	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	



#### D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X	X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
		D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3564-5	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4		MS27039C4-12	SCREW
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER

#### GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (#0.250-#0.257) FOR WEARSHOE INSERTS. C/SINK #0.391/#0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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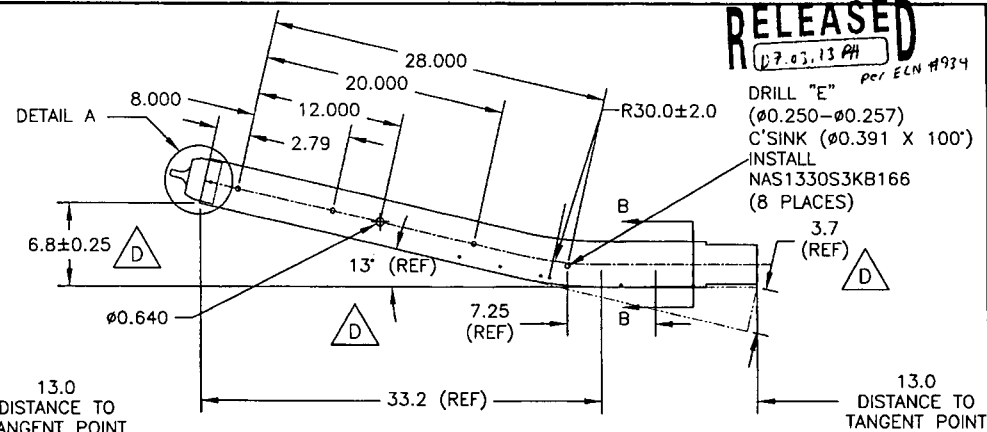
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DESIGN	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
DRAWN BY	PH	
CHECKED	PH	
APPROVED	PH	
DATE	07.01.18	
DRAWING NO.	D3391	REV. F
TITLE	412 FLOAT SKIDTUBE	SHEET 1 OF 5
SCALE		NTS

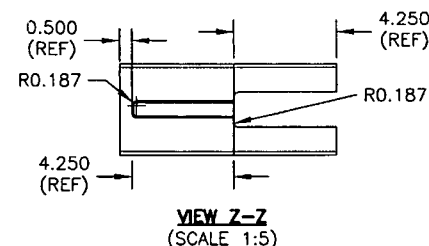
RELEASED  
07.03.13 PH  
per E-LN #934

NO. 317  
WORK ORDER  
WITHOUT NOTICE  
CONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

DRILL "E"  
( $\varnothing 0.250 - \varnothing 0.257$ )  
C'SINK ( $\varnothing 0.391 \times 100^\circ$ )  
INSTALL  
NAS1330S3KB166  
(8 PLACES)




**D3391-021 ASSEMBLY AND BENDING DETAIL**

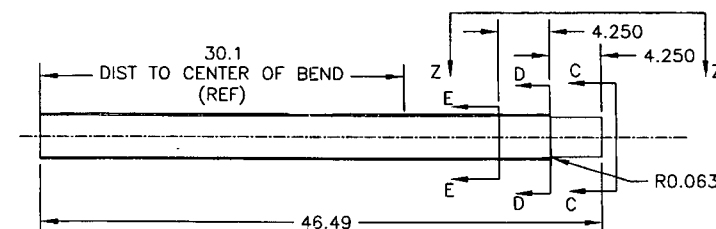


**VIEW Z-Z**  
(SCALE 1:5)

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)


 DRILL "E"  
 (Ø0.250-Ø0.257)  
 C'SINK (Ø0.391 X 100")  
 INSTALL  
 NAS1330S3KB166  
 (12 PLACES)

**SECTION B-B**  
(SCALE 1:5)

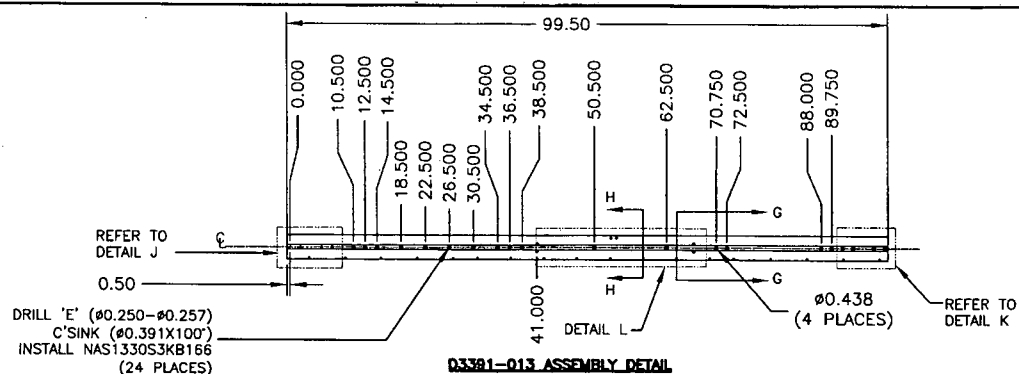


**D3391-1 DRILLING AND CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

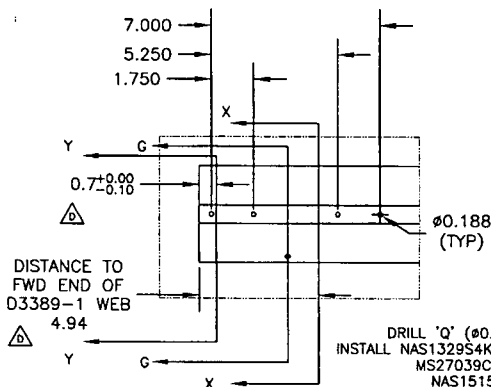
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DESIGN	DRAWN BY	 <b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO.	REV. F
		D3391	SHEET 2 OF 5
DATE		TITLE	SCALE
07.01.18		412 FLOAT SKIDTUBE	1:10

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31317

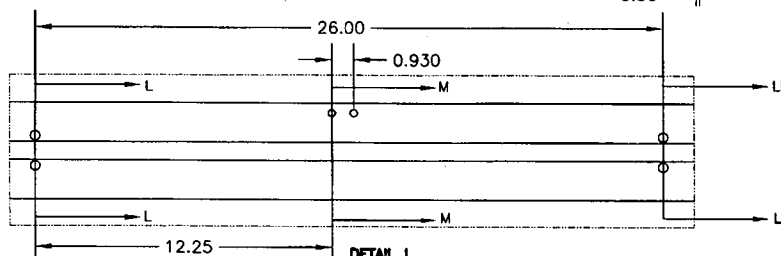


D3391-013 ASSEMBLY DETAIL

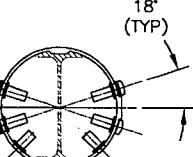


DETAIL J (SCALE 1:5)

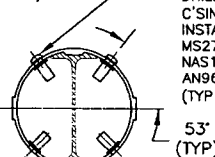
DRILL 'Q' (#0.332-#0.338)  
INSTALL NAS1329S4KB140 INSERT  
MS27039C4-08 SCREW  
NAS1515H4L WASHER  
AN960C416L WASHER  
(TYP 4 PLACES)



DETAIL L (SCALE 1:5)

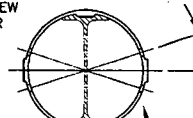


SECTION L-L (SCALE 1:4)

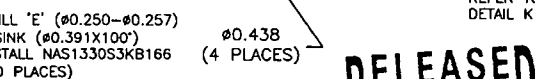


SECTION M-M (SCALE 1:4)

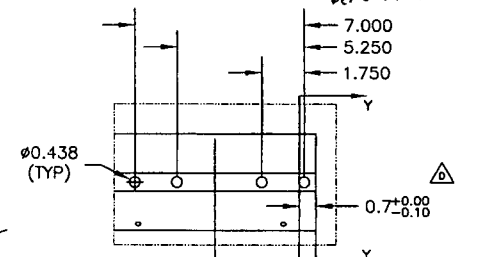
DRILL 'E' (#0.250-#0.257)  
C'SINK (#0.391X100")  
INSTALL NAS1330S3KB116 INSERT  
MS27039C1-09 SCREW  
NAS1515H3L WASHER  
AN960C10L WASHER  
(TYP 4 PLACES)



SECTION N-N (SCALE 1:4)

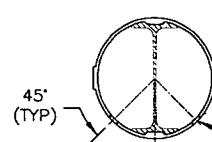


D3391-023 ASSEMBLY DETAIL

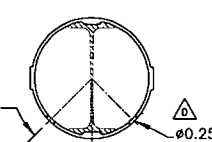


DETAIL K (SCALE 1:5)

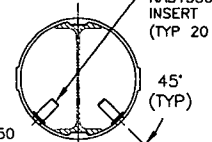
DRILL 'E' (#0.250-#0.257)  
(TYP 4 PLACES)



SECTION Y-Y (SCALE 1:4)



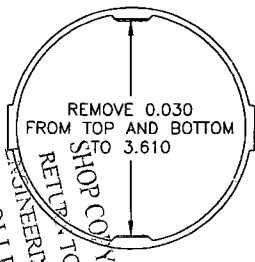
SECTION G-G (SCALE 1:4)



SECTION H-H (SCALE 1:4)

NAS1330S3KB116  
INSERT  
(TYP 20 PLACES)

REMOVE 0.225  
FROM TOP AND BOTTOM  
TO 3.800  
(0.7 FROM BOTH ENDS)



SECTION X-X (SCALE 1:2)

D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X		D3391-013	MID TUBE ASSEMBLY
	X	D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

NO. 21317  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
RETURN TO  
ENGINEERING

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DESIGN  
CHECKED  
APPROVED  
DATE  
07.01.18

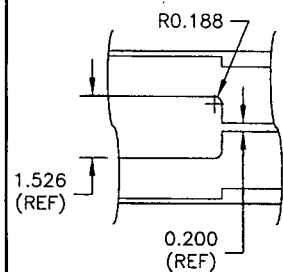
DRAWN BY  
APPROVED  
DATE

DRAWING NO.  
D3391  
TITLE  
412 FLOAT SKIDTUBE

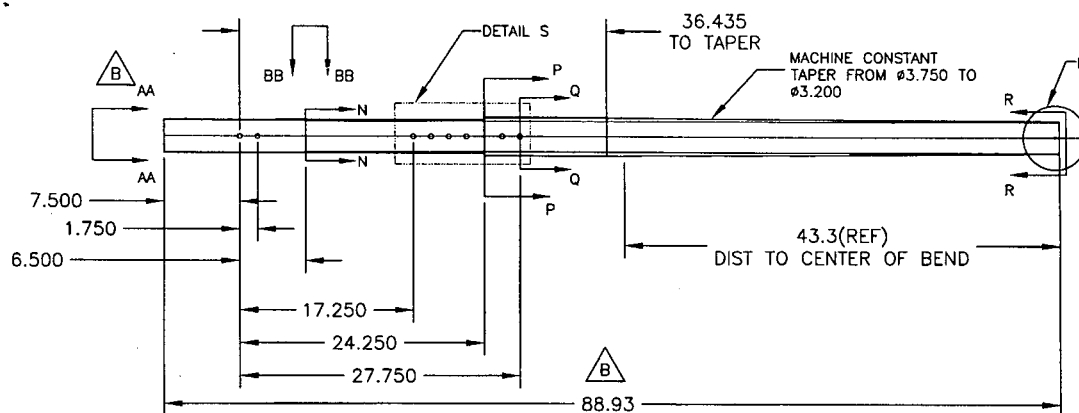
DART DART AEROSPACE USA, INC.  
PORT WADSWORTH, OH

REV. F  
SHEET 3 OF 5  
SCALE  
1:20

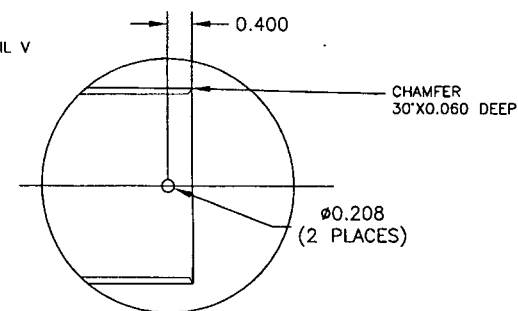
RELEASED  
07.03.13 RH  
DCI E-LN #934



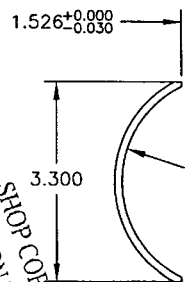
VIEW BB-BB  
(SCALE 1:3)



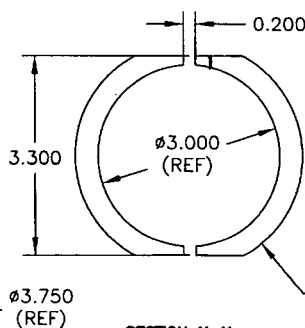
D3391-3 AFT DRILLING AND CUTTING DETAIL  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



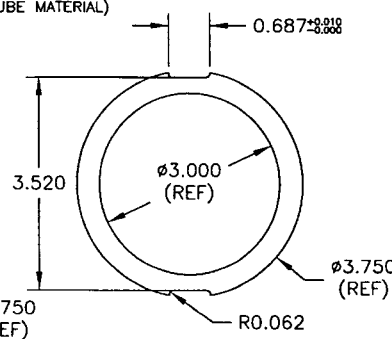
DETAIL V  
(SCALE 1:2)



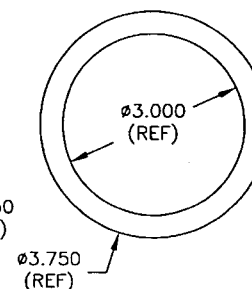
SECTION AA-AA  
(SCALE 1:2)



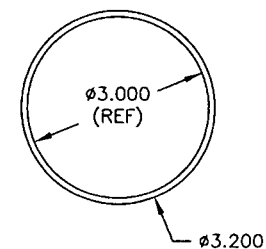
SECTION N-N  
(SCALE 1:2)



SECTION P-P  
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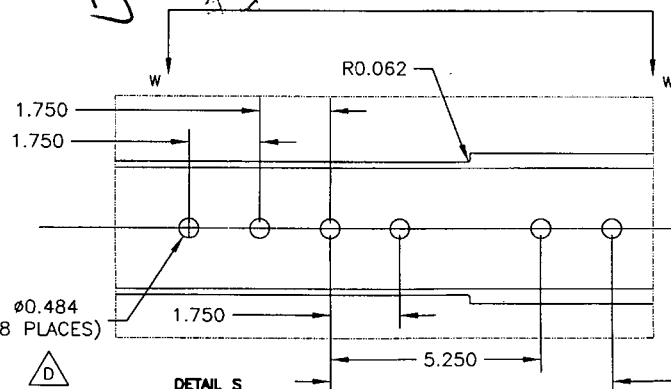


SECTION Q-Q  
(SCALE 1:2)

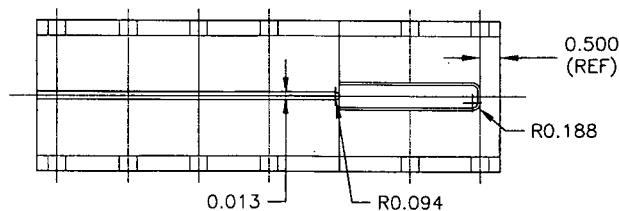


SECTION R-R  
(SCALE 1:2)

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER



DETAIL S  
(SCALE 1:3)



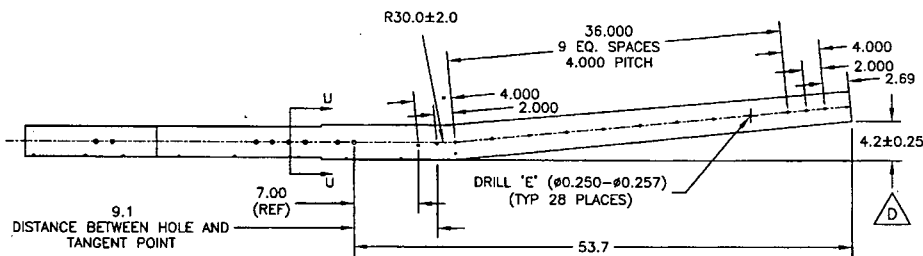
VIEW W-W  
(SCALE 1:3)

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P.C. ELN #934

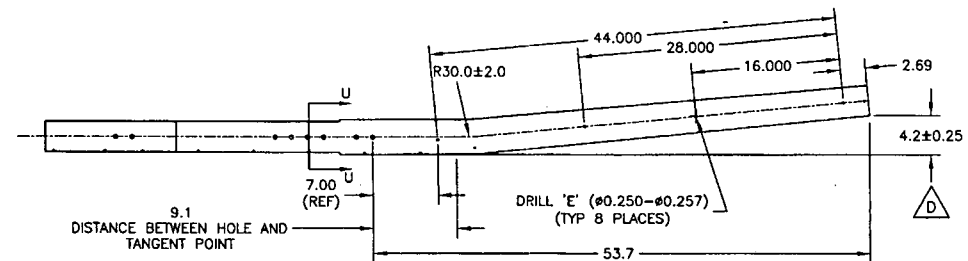
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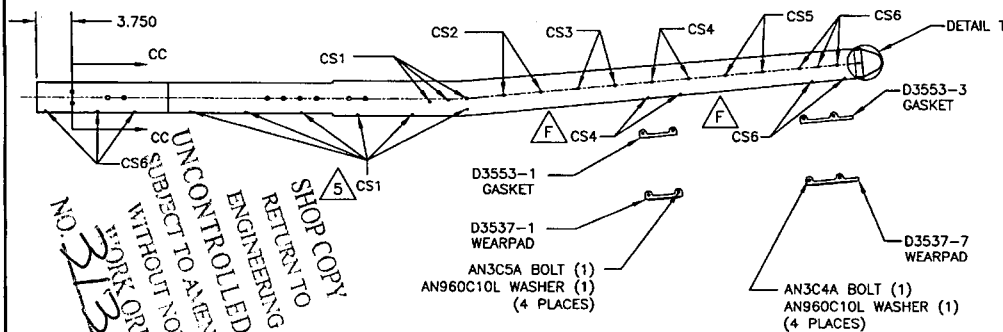
DESIGN PH	DRAWN BY PH	<b>DART</b> DART AEROSPACE USA, INC. PORT HADLOCK, WA	REV. F
CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 4 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	



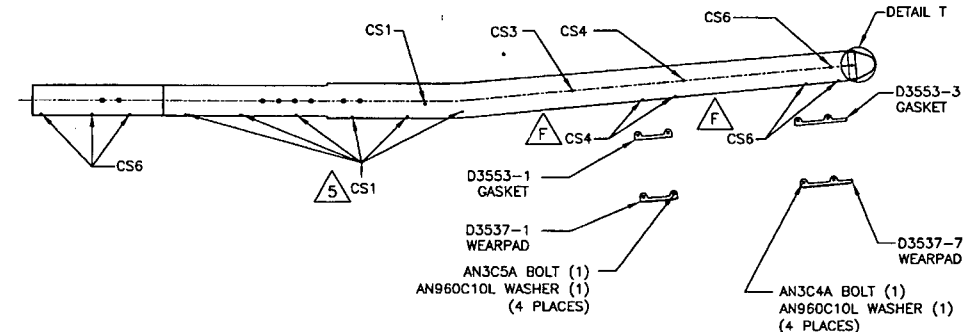
**D3391-015 BENDING AND ASSEMBLY DETAIL**



**D3391-025 BENDING AND ASSEMBLY DETAIL**



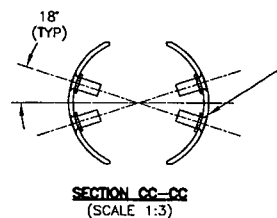
**D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)



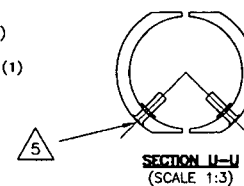
**D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL**  
(SEE TABLE)

**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER



DRILL 'Q' (#0.332-#0.338)  
C'SINK (#0.529X100")  
NAS1330S4KB151 INSERT (1)  
(4 PLACES)



AN3C4A BOLT (1)  
NAS1515H3L WASHER (1)  
AN960C10L WASHER (1)  
(2 PLACES)  
DETAIL T (SCALE 1:3)  
D2646 AFT CAP  
SEAL WITH SIKAFLEX-241/-291

C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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CHECKED H	APPROVED H	DRAWING NO. D3391	SHEET 5 OF 5
DATE 07.01.18	TITLE 412 FLOAT SKIDTUBE	SCALE 1:12	

**RELEASED**  
07.03.13 RH  
per ECN #534



